

Date: Monday, 6/5/2006 7:47:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 27370	
Estimate Number : 10280	
P.O. Number : N/A	Part Number : D3137043
This Issue : 6/5/2006 S.O. No. : N/A	Drawing Number : D3137 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 26413	Material : N/A
Written By : <i>See comment below</i>	Due Date : 6/30/2006 Qty: 8 Um: Each
Checked & Approved By : <i>06.06.05</i>	
Comment : Est Rev. 04.02.18 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B0500X02000	17-4 SS Bar
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Comment: Qty.: 0.4875 f(s)/Unit Total : 3.9001 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B0.500x02.000)
 Identify for D3137-7
 Batch: *M19572*

JL 06/07/24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: (.500" x 2.000") 5.570" long

JL 06/07/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7

2-Deburr

3-Scribe batch number

J.G/J.L 06/07/26


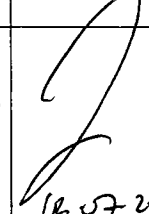

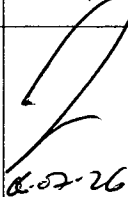
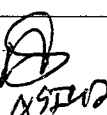
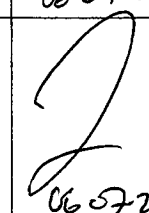

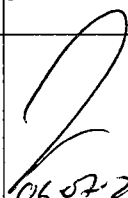
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--




Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G/J.L 06/07/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/26	3	1 Part FLEW out of fixture		make sure part sits properly in J.G scrap- destroy and Replace	J.G 06/07/26			
06/07/26	3	1 Part FLEW out of fixture		make sure pitbull clamps are well secured and part sits properly scrap- destroy and Replace	J.G 06/07/26			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/21

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:47:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27370

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/27 x 8

6.0

D31373

Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-3

GUIDE B26888

MS 06/07/27 8

7.0

D31375

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-5

Washer B27246

MS 06/07/27 8

8.0

MS24694S101

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS24694-s101

Screw M16941

MS 06/07/27 8

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3137-043 as per Dwg D3137

MS 06/07/27 8

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/07/27 x 8

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: /

MS 06/07/28 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:47:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27370

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/07/31 (8)

Job Completion



06.07.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 27370
Description: Bracket		Part Number: D3137-7
Inspection Dwg: D3137	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	0.432	-			
0.615	+/-0.010	0.614	-			
0.200	+/-0.010	0.202	✓			
0.380	+/-0.010	0.381	-			
0.262	+/-0.010	0.264	✓			
Ø0.500	+0.005/-0.000	0.501	✓			
0.79	+/-0.030	0.803	✓			
2.79	+/-0.030	2.77	✓			
Ø0.560	+0.005/-0.000	0.560	✓			
0.595	+/-0.010	0.596	✓			
0.950	+/-0.010	0.946	✓			
0.605	+/-0.010	0.604	✓			
1.880	+/-0.010	1.893	✓			
2.48	+/-0.030	2.497	✓			
4.975	+/-0.010	4.980	✓			
5.41	+/-0.030	5.422	✓			
0.032	+/-0.010	0.026	✓			
0.063	+/-0.010	0.063	✓			
R0.062	+/-0.010	0.062	✓			
0.162	+/-0.010	0.152	✓			

Measured by: Ep/S.G	Audited by: [Signature]	Prototype Approval:	N/A
Date: 06/07/25	Date: 06/07/27	Date:	N/A

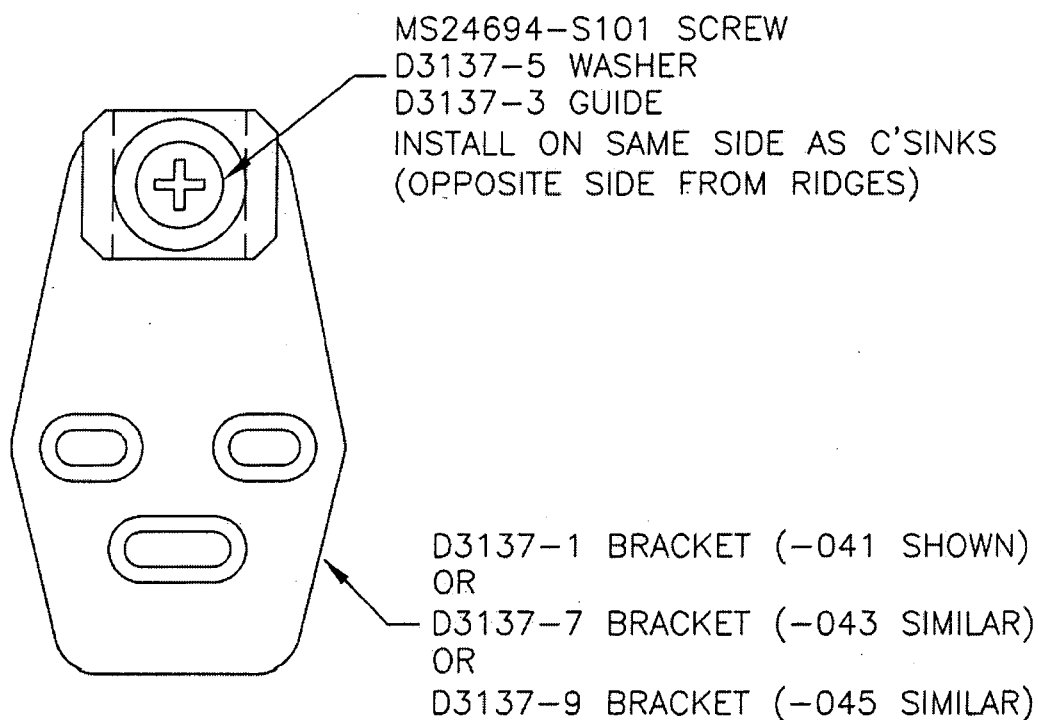
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	[Signature]



DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09



D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

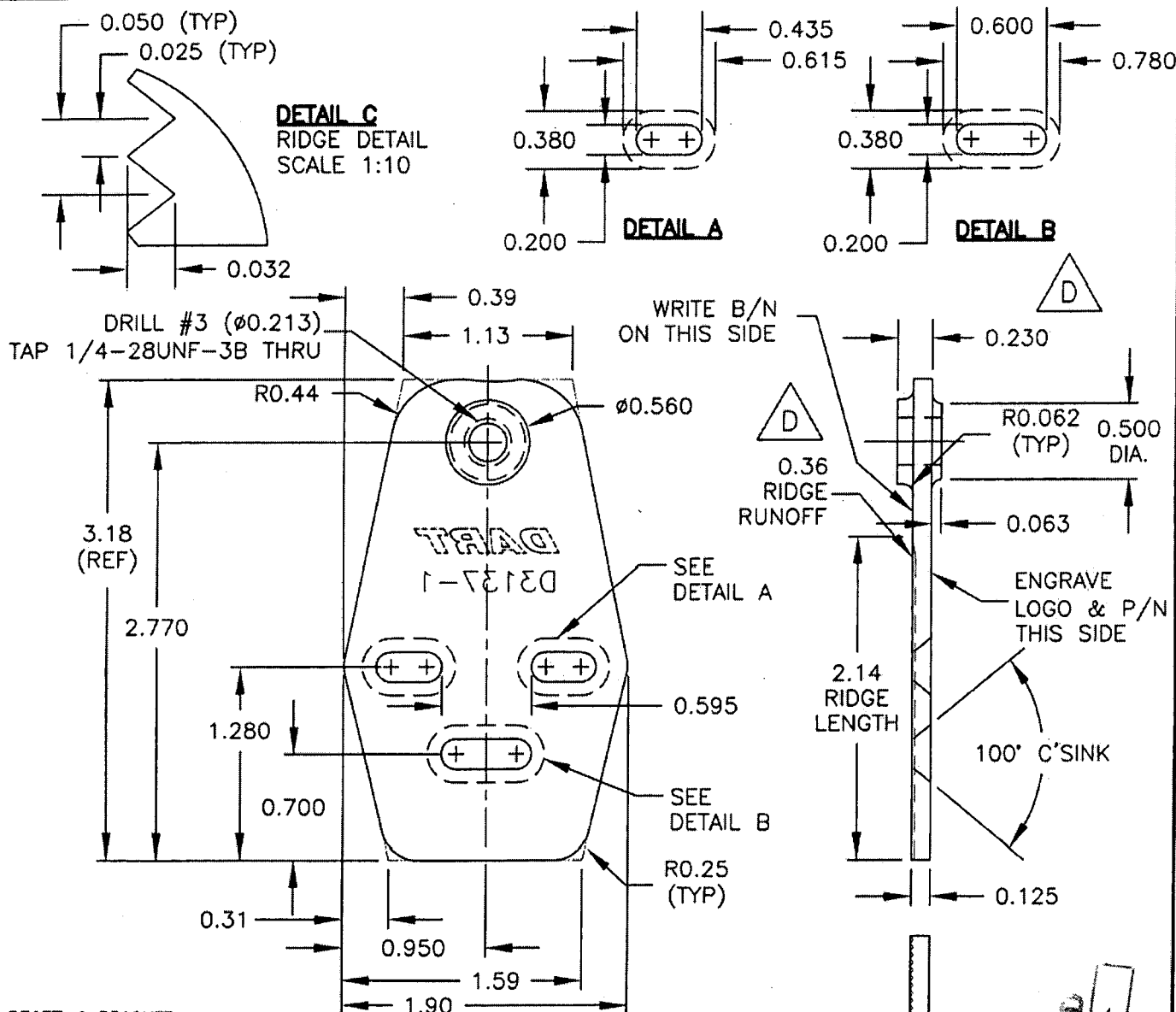
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DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3137	REV. E SHEET 2 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3137-1 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

SEE DETAIL C

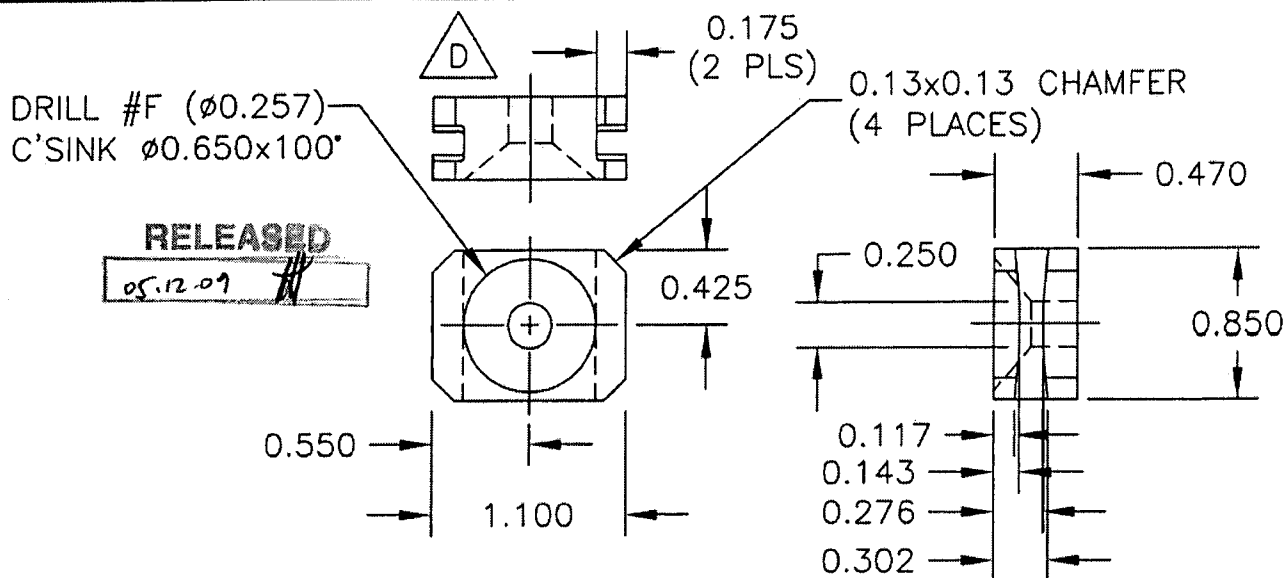
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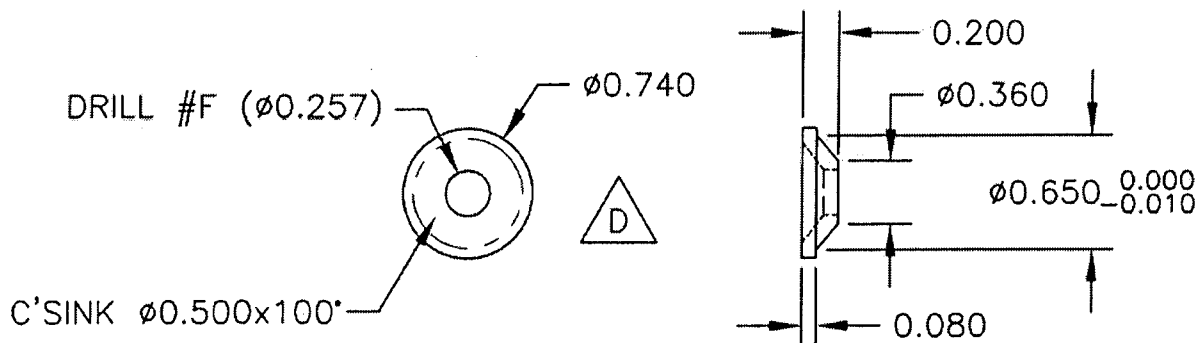


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3137	REV. E SHEET 3 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

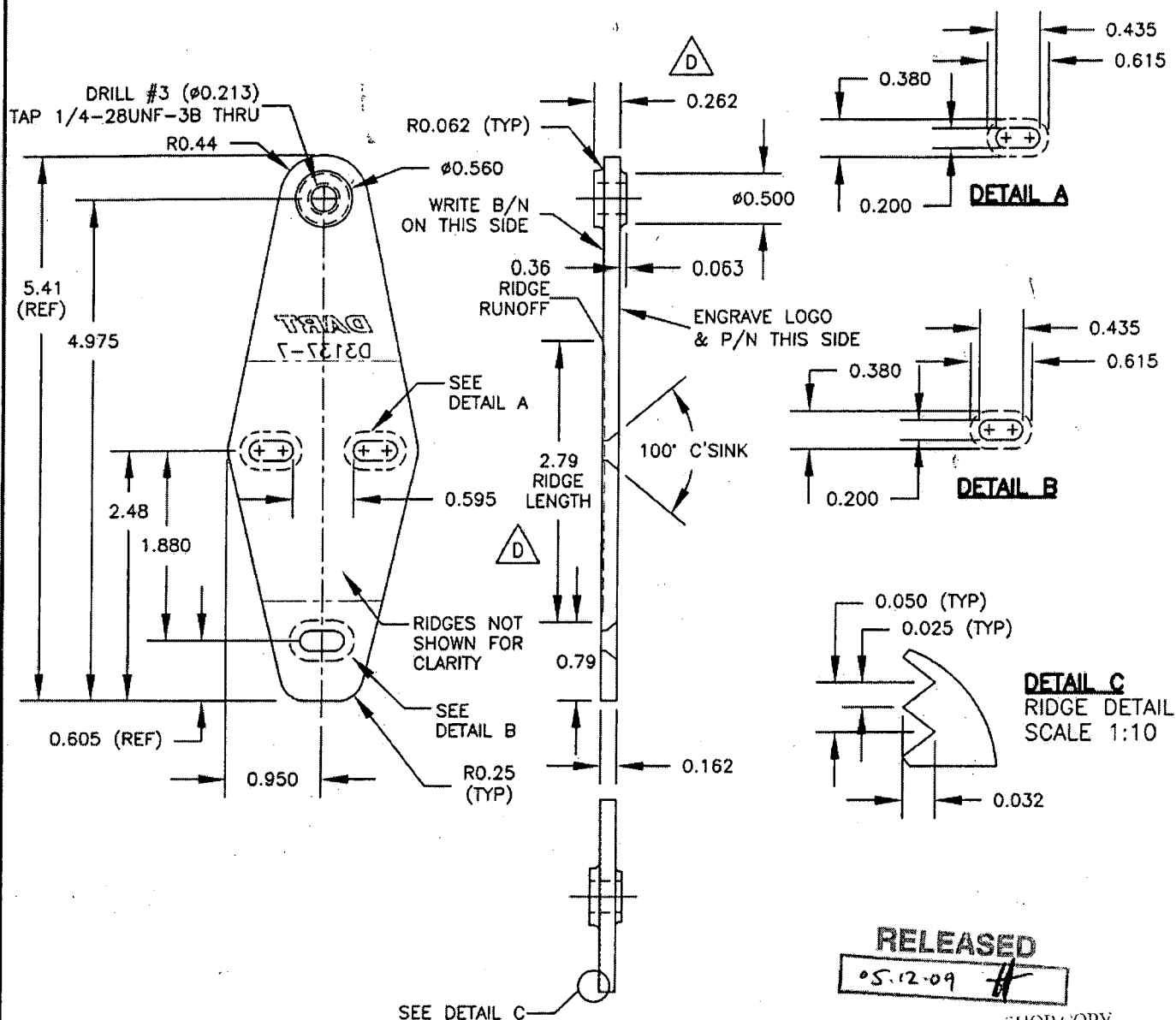
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3137	REV. E SHEET 4 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3

**D3137-7 BRACKET:**

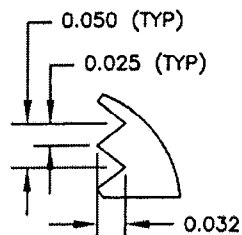
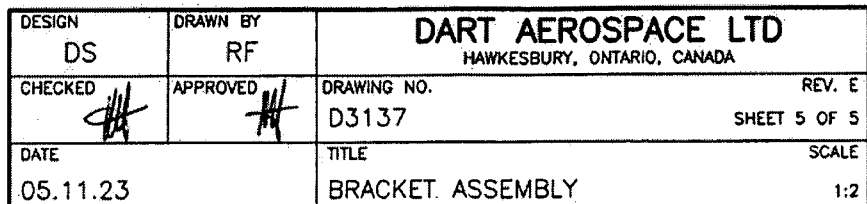
- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20" & P/N USING 0.15" LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

RELEASED05.12.09 *[Signature]*

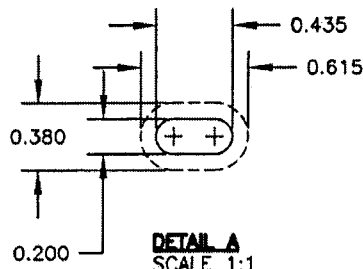
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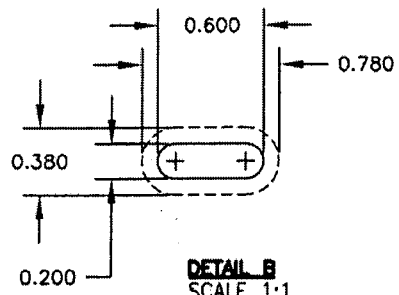
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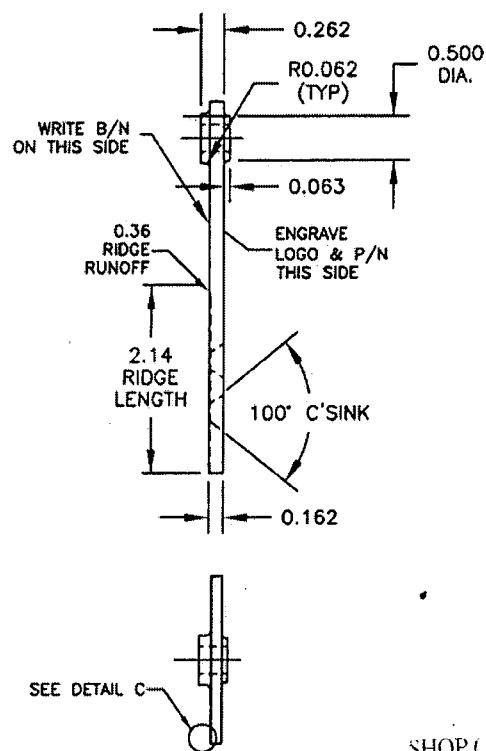
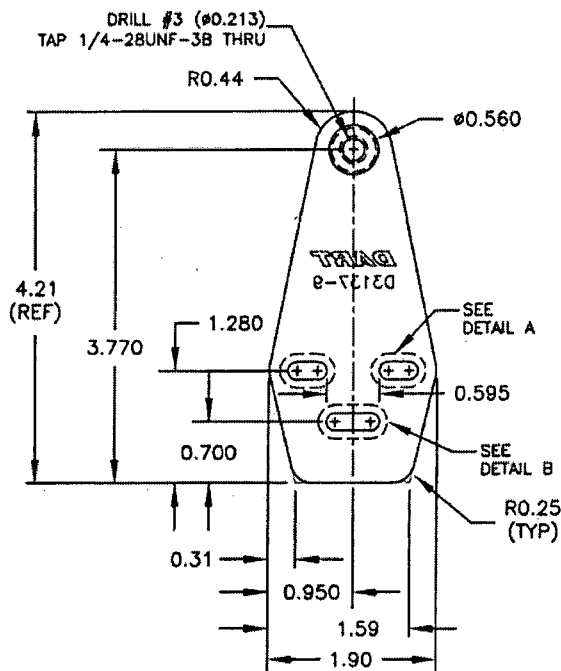
DETAIL C
RIDGE DETAIL
SCALE 1:20



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1





03137-9 BRACKET:

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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